



Product Data Sheet

Transpoxy Tar KPC210

Product description.

A polyamine cured coal tar epoxy coating designed for use on areas where maximum water resistance, abrasion and chemical resistance is required. Recommended for steel and concrete pipeline, pilling, water gates and jetties in all submerged, semi-submerged and buried environments. It has the Lloyds approval for corrosion control.

Physical properties.

Colour	Black
Texture	Semi-gloss
Volume Solids	80% \pm 2%
Specific gravity	1.47 gr/ml
Flashpoint	>25°C

	Dry film thickness per coat (μ)	Wet film thickness per coat (μ)	Theoretical spreading rate (m^2/l)
Range	100 – 300	125 – 375	7.8 – 2.5
Recommended	150	300	5.1

Application data.

<u>Mixing ratio</u>	By weight, base to hardener: 90 to 10. By volume, base to hardener: 84 to 16.
<u>Potlife</u>	10°C: 8 hours, 23°C: 4 hours, 30°C: 3 hours.
<u>Induction time</u>	20 minutes.
<u>Guiding data Airless spray</u>	Pressure at nozzle: 180 -250 bar. Nozzle size: 0.48 - 0.78 mm. Spray angle: 40 - 80 degrees. Volume of thinner: 0 - 5%.
<u>Guiding data Airspray</u>	Pressure. 4 - 6 bar. Nozzle size: 1.5 - 2.0 mm. Volume of thinner: 0 - 10%.
<u>Brush/Roller</u>	Suitable. Multicoats are required to achieve the specified dry film thickness. Volume of thinner: 0 - 5%.
<u>Thinner/Cleaner</u>	Transocean Epoxy Thinner 6.03. If thinning is necessary, this should be added after mixing of the two Components. Avoid excessive thinning as it will result in lower sag resistance and slower cure.

Drying and recoating times (1).

Substrate temperature	Touch dry	Dry to handle	Full cure	Dry to recoat	
				Minimum	Maximum (2)
10 °C	6 hours	24 hours	10 days	24 hours	4 days
23 °C	3 hours	12 hours	7 days	12 hours	5 days
30 °C	1 hours	8 hours	4 days	8 hours	1 day

- (1) The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, preceding paint system etc
- (2) The surface should be dry and free from contaminants prior to overcoating. When the maximum recoating time is exceeded it may be necessary to roughen the surface to ensure intercoat adhesion. When recoating with single pack products, maximum recoat interval is limited to 16-24 hours. When in doubt, consult your nearest Transocean office.

Surface preparation.

Steel	Oil and grease should be removed by solvent cleaning according to SSPC-SP1. Remove weld spatter and smooth weld seams and sharp edges as applicable. Abrasive blasting: min. Sa2,5 – ISO 8501:1. Apply Transpoxy Tar KPC210 immediately after the steel has been blasted and the quality of preparation has been approved. Transpoxy Tar KPC210 may also be applied on Transpoxy primers such as Transozinc Epoxy Primer 1.55. Ensure that primed surfaces are dry and free from salts and other contaminants prior to overcoating.
Repair	Corroded areas should be power tool cleaned to ISO-St3 or blast cleaned to ISO-Sa2 or better. Existing systems should be dry and free from loose paint, salt, grease and other contaminants prior to overcoating.

Recommended paint system.

A typical system for immersion conditions is shown below.

Transpoxy Tar KPC210	2 x 150 µ dft.
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Application conditions.

The temperature of the substrate should be at least 10°C and at least 3°C above the dew point of the air. Temperature and relative humidity should be measured in the vicinity of the substrate.

The maximum recommended surface temperature is approx. 40°C. Higher steel temperatures are acceptable provided dry-spray is avoided by proper spray application and extra thinning if required. In extreme cases it may be necessary to reduce film thickness in order to avoid sagging.

When applying the paint in confined spaces, provide adequate ventilation during application and drying. The temperature of the mixed paint should be at least 15°C, otherwise extra solvent may be required to obtain a proper application viscosity.

Storage and shelf life.

The product must be stored in accordance with national regulations. The cans are to be kept in a dry, cool, well ventilated space and away from source of heat and ignition. Cans must be kept tightly closed.

Product Limitationst

In common with all epoxies, Transpoxy Tar KPC210 will chalk and discolour on external exposure and weathering. This phenomenon is not detrimental to the paint's anti-corrosive performance. Maximum film build in a single coat is best achieved by airless spray. For brush and roller applications, multiple coats will be required to achieve the required DFT. Transpoxy KPC210 is not suitable for overcoating with other finishes as the product has the tendency to bleed.

Health and safety.

Observe the precautionary notices on the label of the container. A material safety data sheet is available upon request and national or local safety regulations should be followed. This product is intended for use by professional applicators.

As a general rule, avoid skin- and eye contact by wearing overalls, gloves, goggles, mask, etc. Spraying should be carried out under well-ventilated conditions. This product contains flammable materials and should be kept away from sparks and open flames. Smoking in the area should not be permitted.

Disclaimer

The information in this data sheet is provided to the best of our knowledge. However, we have no control over either quality or condition of the substrate and other factors affecting the use and application of this product. Therefore, we cannot accept any liability whatsoever or howsoever arising from the performance of the product or for any loss or damage arising from the use of this product. We reserve the right to change the product without notice.



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